

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018100**Date Inspected:** 08-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen, Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, OBG BIKE PATH (NWIT # 07278)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A5-031-076, 077, 080~083

BK004A5-031-056, 057, 060~063

BK004A7-031-232, 183, 198, 231, 167, 182

BK004A4-031-015

BK004A7-031-031, 032, 091, 092

BK004A4-031-040, 041

BK004A7-031-037, 038, 043, 044, 097, 098, 103, 104

BK004A4-031-066, 067

BK004A7-031-049, 050, 055, 056, 109, 110, 115, 116

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This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

U-RIB SPLICE PLATE

FCAW welding of weld joints 001 & 002 located on GGL-MQ-1958-44.

Welder is identified as 052075. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joints 001 & 002 located on GGL-MQ-1958-22.

Welder is identified as 057180. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

OBG BIKE PATH, END PLATE REPAIR

FCAW welding of weld joint 043 located on BK004A1-030.

Welders are identified as 053869 & 040302. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR-1.

OBG BIKE PATH, VERTICAL ANCHOR HOUSE PLATE

SMAW welding of weld joints 003 & 005 located on BK004A8-028.

Welder is identified as 056200. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

SMAW welding of weld joints 025 & 026 located on BK004A8-028.

Welder is identified as 056200. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

OBG BIKE PATH, BK004A-025

During random in process inspection this QA inspector observed that AB/F NDT personnel Mr. Tao Lin Yin was performing Magnetic Particle Testing on the temporary attachment removal area of base metal of deck plate of OBG bike path. During inspection AB/F NDT personnel found several of MT linear indications and ZPMC personnel excavated those locations upto 3~4mm deep to remove those MT indications. This issue has been discussed with ZPMC CWI Mr. Qiu Wen and ZPMC agreed to do the repair as per contract document and approved repair procedure.

BAY 11

OBG BIKE PATH, BK004A-020

During random in process inspection of Orthotropic Box Girder (OBG) member identified as BK004A-020 this QA observed an arc strike on Piece Mark (PCMK) identified as bearing plate. This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Mr. Wang Chuan Xin of this issue. Mr. Wang Chuan Xin informed this QA that the arc strike would be corrected in a manner compliant with the contract documents.

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TOWER BRACKET

SMAW welding of weld joint 019A located on ND1-BRSA5-2.

Welder is identified as 040724. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-Tc-U5b.

TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 053B located on ESD1-TL5-2B/F.

Welder is identified as 040699. ZPMC QC is identified as Mr. Xu Jie.

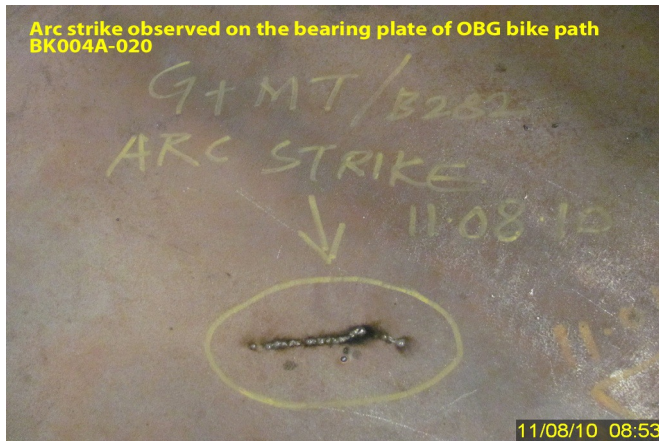
The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c.S-1.

SAW welding of weld joint 079B located on WSD1-TL5-4B/F.

Welder is identified as 044550. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c.S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer